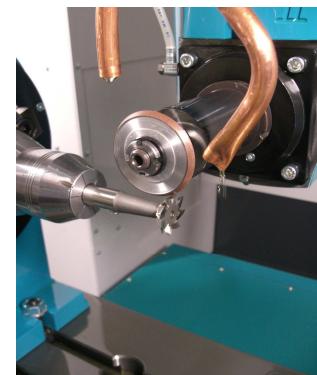
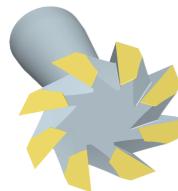
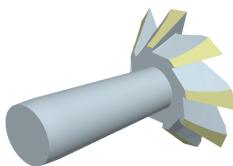
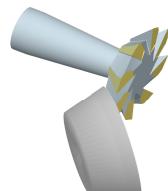
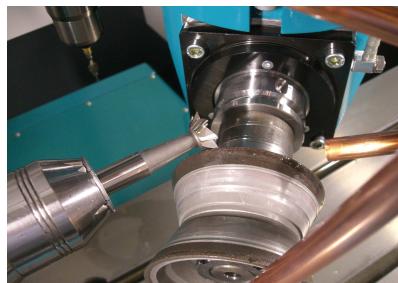


Dove-Tail Cutter Ø25 Z10

A4-110

Dovetail cutters can be ground in one setup on the O. D. of the backtaper as well as in the flute. For some extreme geometries a small wheel - 30 to 50 mm in diameter - has to be used to grind the bottom of the backtaper flute. The positioning of the wheel for grinding the O.D. on the 45 degree backtaper allows to use standard wheels and standard clamping for the tool.



1. Cycletime for Resharpening

Tool specifications					
Diameter 25 mm, Z 10, Length of cutting edge 6 mm					
Material HSS					
Operations					
Probe	2000	120	80	100	120
Feed [mm/Min]		4	2	1	1
Power [kW]		20	20	30	30
Cutting feed [m/s]					
Used wheels	9	9	4	2	
Grinding time [s]	16	86	96	75	118
Total cycle time	6 Min 29				

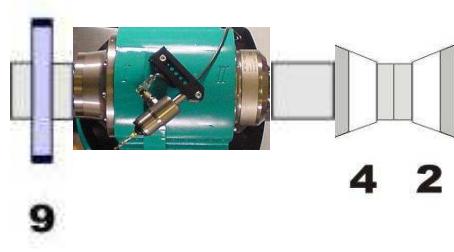
The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

9 Ø40 1V1 20 - 30° B91

4 Ø75 11V9 B91

2 Ø75 11V9 B91



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : CORVUS GDS, GEMINI DMR, NORMA CFG

Control: Fanuc 160i

Coolant: Synthetic Oil, pressure 6 - 7 bar

Software: Quinto 4.2, DXQ

responsible engineer: OP, 8.2.08

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